

Date: Tuesday, 7/10/2007 1:05:44 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	PLUG
Job Number	33450			
Estimate Number	10178			
P.O. Number	N/A			
This Issue	7/10/2007	S.O. No. N/A		
Prsht Rev.	NC			
First Issue	N/A	Type MACHINED PARTS		
Previous Run	32651			
Written By				
Checked & Approved By		7/10/07, 10		
Comment	Est D 02.08.22	Make in Cobra KJ		
	est E 06.12.11	ecn 836	EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0625	6061-T6 Round Bar .625"	
	Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s)	28.5'	20 07/11/08
	Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)		
	1100-0 (QQ-A-225/1) Ø0.625" Rod		
	(M5052H32R0.625) or (M6061T6R0.625)	Batch M1061b3	DJP 07/11/07
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
	Comment: HARDINGE CNC LATHE SMALL		
	1-Make as per Dwg D2594-1 and Folio FA262.		
	2-Break all sharp edges 0.010 max.		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		DJP 07/11/07 20 07/11/08
4.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK		20 07/11/08
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
	Comment: HAND FINISHING RESOURCE #1		
	Acid etch and alodine as per QSI 005 4.1		
			07 - 11 - 09
			2516

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 33450

Part Number: D25941

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



*m/105914*



516

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

*FL 07/11/14*

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



516x

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*m-1*

*07/11/14*

8.0 PACKAGING 1

PACKAGING RESOURCE #1



516x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP 8*

*m-1 07/11/14*

9.0 QC21

FINAL INSPECTION/W/O RELEASE



516

Comment: FINAL INSPECTION/W/O RELEASE

*D 07/11/15*

Job Completion



*u 07.11.15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33450
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>DJP</u>	Audited by: <u>grf</u>	Prototype Approval: N/A
Date: <u>07/11/07</u>	Date: <u>07/11/07</u>	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.12.20	Dwg Rev. updated	KJ/JLM	

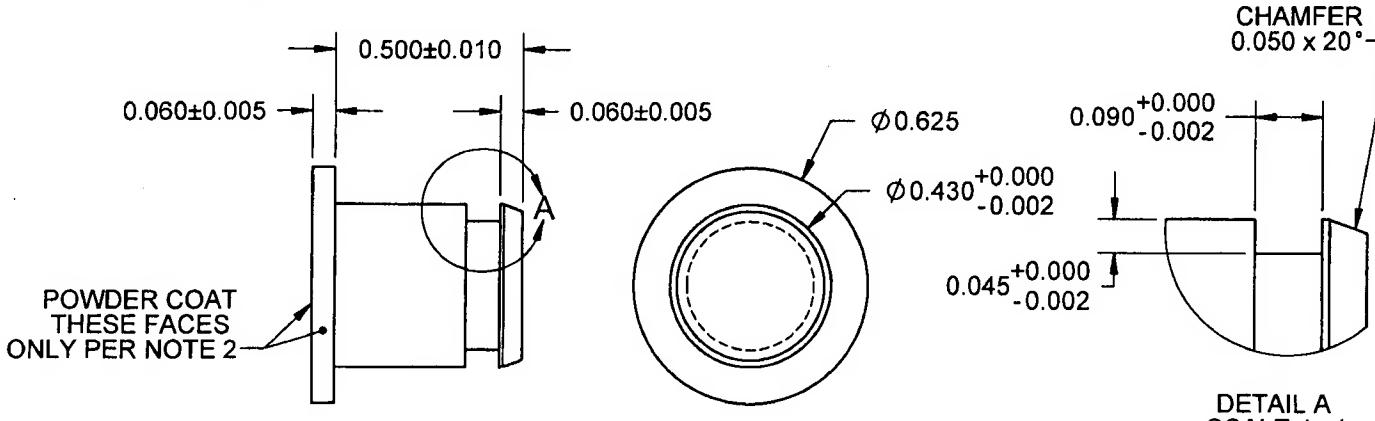
**DART**

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>LE</i>	APPROVED <i>CH</i>	DRAWING NO. D2594	REV. C	SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG	SCALE	2:1

PRINTED 06/11/2020

06.11.28 *CH*

REV	DATE	DESCRIPTION
A	96.09.16	NEW ISSUE
B	97.03.15	ADD GROOVE AND O-RING
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE



### D2594-1 PLUG

#### D2594-1 PLUG NOTES:

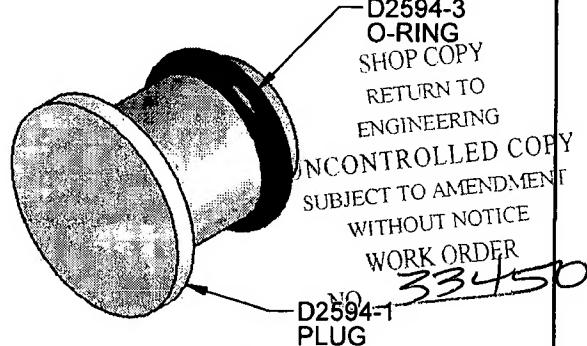
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

#### D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

#### PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



### D2594 PLUG ASSEMBLY

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